

Work Order ID 102524

Tuesday, May 28, 2013 2:47:35 PM

102524

ASAP

Page 1

Item ID: D3564-3

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Item Name: Wearshoe

Stop ***NS2***

Start Date: 5/28/2013 Start Qty: 10.00 ***10***

Cust Item ID:

Required Date: 6/4/2013 Req'd Qty: 10.00 ***10***

Customer:

Reference:

Approvals: Process Plan: *mf* Date: *13-5-28* Tooling:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3564	Rev D

100 0.00

100 FLOW WATER JET

Waterjet Memo 0.00

FLOW CNC Waterjet 1-Cut as per Dwg D3564 ***** (D3564-1F) ***** Dwg Rev: REV D Prog
Rev: REV D 2-Deburr if necessary

10

φ

Jm

13-05-29

110 0.00

110 QC2- Inspect parts off machine FAI/FAIB

QC Memo 0.00

Quality Control

10

φ

Jm 13-05-30

120 0.00

120 QC8- Inspect parts - second check

QC Memo 0.00

Quality Control

27

10

13-5-30

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Page 2

Item ID: D3564-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Wearshoe

Stop *NS2*

Start Date: 5/28/2013 Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/4/2013 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Brake NC

NC BRAKE

0.00

Memo

0.00

Brake NC

Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155 Form Joggle as per Dwg D3564 on brake using Jig DT8157

10

SB 13/05/20

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Ensure joggle as per dwg D3429

21
BS 30

10

150

150

Large Fab

Large Fab

Large Fab

0.00

Memo

0.00

Qty Description Batch A/R 2059B Hardcoat
11/25/37 Weld hardcoat as per Dwg D3437

10 12/11/13 13-6-3

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Item ID: D3564-3

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N9000040100

Setup Start ***NS1***

Revision ID:

Item Name: Wearshoe

Stop ***NS2***

Start Date: 5/28/2013 Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/4/2013 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00

160

QC

Memo

0.00

Quality Control

AS 273 BGS

10

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

AS 273 BGS

10

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

180

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

3200F

270

2710

10 X 4 m / 13/06/04

M121279

Work Order ID 102524

102524

Page 4

Tuesday, May 28, 2013 2:47:35 PM

Item ID: D3564-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Wearshoe

Stop ***NS2***

Start Date: 5/28/2013 Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/4/2013 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00

190

QC

Memo

0.00

Quality Control

10 φ 13-6-4

200

Identify as per dwg & Stock Location: _____

0.00

200

Packaging

Memo

0.00

Packaging

Ship

10x 13-6-5

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

MLJ 13-06-05

MF 13-6-5

Picklist Print

Tuesday, May 28, 2013 2:47:35 PM

Page 1

Work Order ID: 102524

Parent Item: D3564-3

Parent Item Name: Wearshoe

Start Date: 5/28/2013

Required Date: 6/4/2013

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-03-08 ec
 IPP Rev:B As per Rev C 07-07-09 JLM
 IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			100	sf	446.0842	1.1	11.578947	11.6	13.05.29	

Location

Loc Qty

Loc Code

MAT020

446.0841688

122245

0.1713688

123136

140.8

124428

23.61

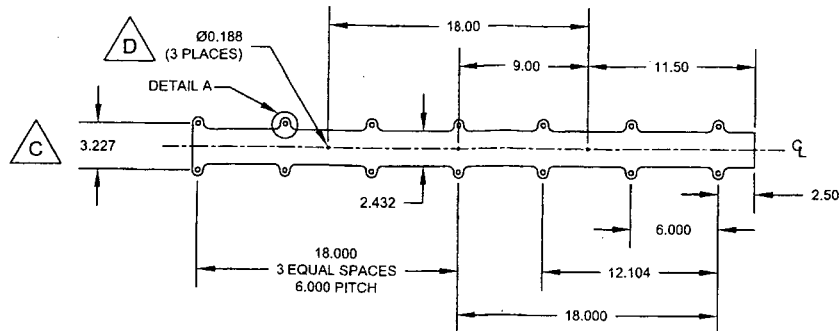
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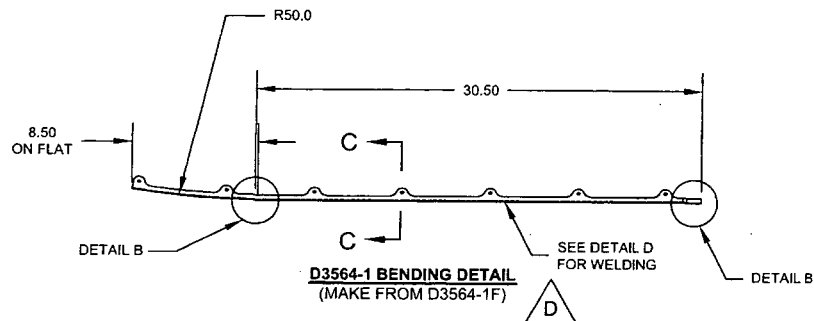
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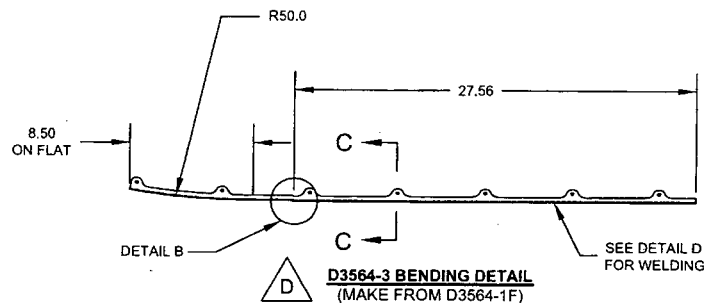
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D3564-1F FLAT PATTERN



D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C

WEIGHTS:

D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

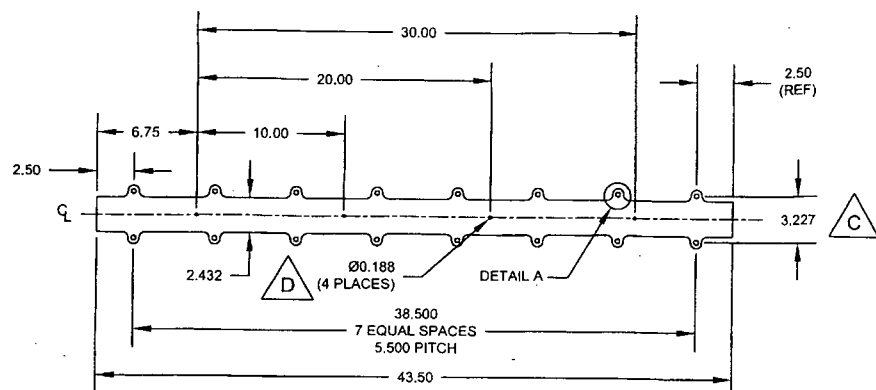
D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. REV. D D3564 SHEET 1 OF 3 TITLE SCALE WEARSHOE 1:8	
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21		

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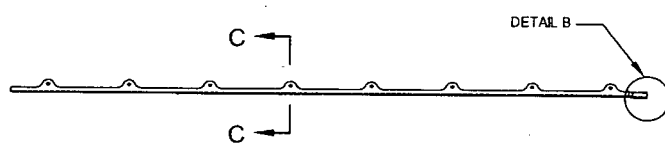
RELEASED
07.09.04

UNDER REVIEW
First change
OK 9/11/23

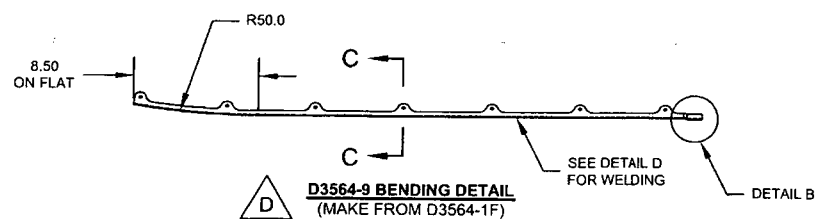
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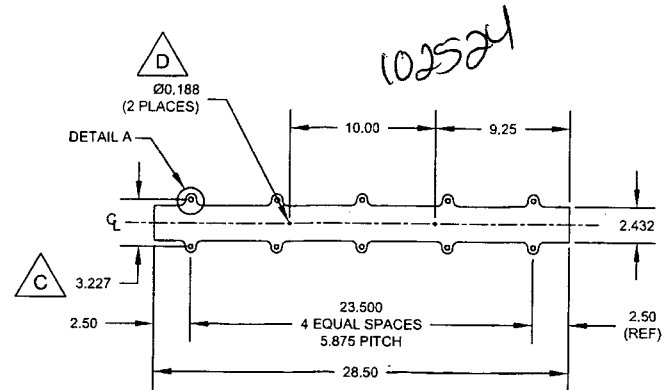
D3564-5F FLAT PATTERN



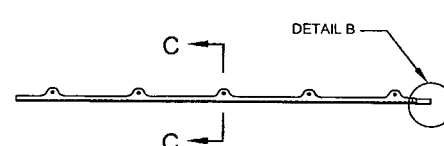
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



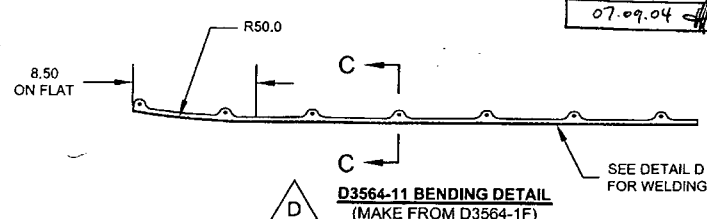
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



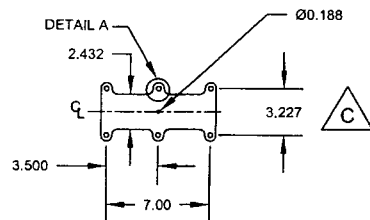
D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

UNDER REVIEW
OK 07.11.28

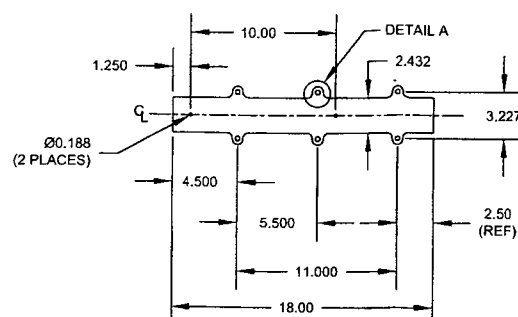
RELEASED
07.09.04

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO. D3564	REV. D
MFG. APPR.	PH	SHEET 2 OF 3	
APPROVED	PH	SCALE	
DE APPR.	PH	WEARSHOE	
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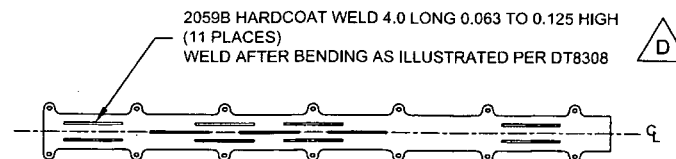
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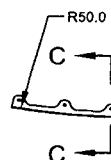
D3564-13F FLAT PATTERN



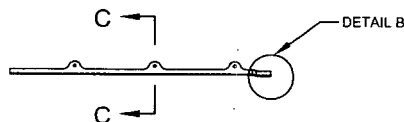
D3564-15F FLAT PATTERN



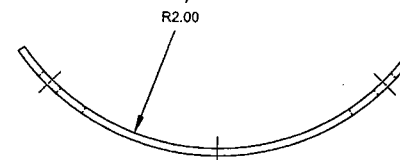
DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)



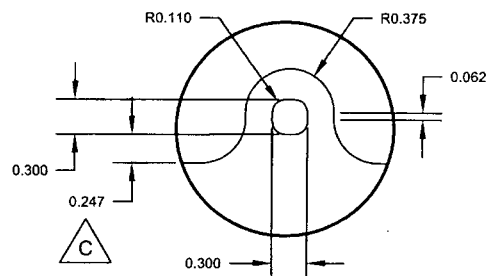
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



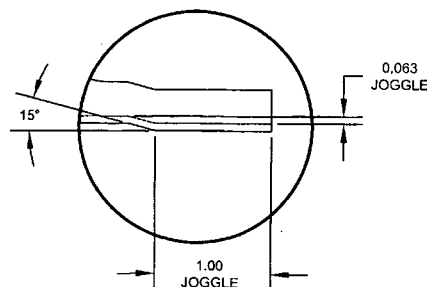
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

RELEASED

07.09.04

UNDER REVIEW
OK 07.11.28

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 3 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
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DART AEROSPACE LTD		Work Order: 102524
Description: Wearshoe		Part Number: D3564-3
Inspection Dwg: D3564	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.238	✓		V	Jkm-01
2.432	+/-0.010	2.427	✓		V	
2.50	+/-0.030	2.447	✓		V	
6.000	+/-0.010	6.000	✓		V	
12.104	+/-0.010	12.104	✓		T	Jkm-06
18.000	+/-0.010	18.000	✓		T	
18.000	+/-0.010	18.000	✓		T	
18.00	+/-0.030	18.000	✓		T	
9.00	+/-0.030	9.00	✓		T	
11.50	+/-0.030	11.50	✓		T	
0.300 x 0.300	+/-0.010	.309	✓		V	
Ø0.188	+0.005/-0.001	0.188	✓		V	
R0.375	+/-0.010	0.375	✓		RG	
0.063	+/-0.010	0.063	✓		V	

Measured by: A. I. M.	Audited by: 27	Prototype Approval:	N/A
Date: 13.05.29	Date: 13.3.30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	KJ/JLM	
B	08.09.04	Dwg Rev updated	KJ/DD	